

Thursday, 17/07/2008 12:31:10 PM
Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SEAT BACK (AFT FACING LH/RH)
Job Number	: 40588		
Estimate Number	: 13363		
P.O. Number	:	Part Number	: D37743
This Issue	: 17/07/2008 S.O. No. :	Drawing Number	: D3774 REV <i>B</i> <i>08.03.12</i>
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : R&D THERMOFORMING	Drawing Revision	: A
Previous Run	: 39704	Material	:
Written By	:	Due Date	: 31/07/2008
Checked & Approved By	: <i>JUD 08.7.17</i>	Qty:	<i>62</i> Um: Each
Comment	: Est. REV:A New Issue 08.06.04 DL verified by:DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-3

Set up clamping frame as per folio

DL 08.07.18.

2.0

6x MLEXS125F6002904*- M105330*

GE PLASTICS LEXAN SHEET

*1x MLEXS 093 F600607**M105494*

Comment: Qty.: 10.6670 sf(s)/Unit Total: 21.3340 sf(s)

GE PLASTICS LEXAN SHEET

batch: *M105330**DL 08.07.18.*

3.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*6x 32" x 44"**DL 08.07.18.*

4.0



THERMOFORMING

THERMOFORMING MACHINE



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. *3774/3* *D3281* and Folio *EIA 011 EIA 021*Dwg. Rev. *AB*Folio Rev. *A**6x MLEXS125 F6002904**2x MLEXS 093 F600607**DL 08.07.18.*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng Prod Mgr	Approval QC Inspector	
08.07.18	4	Pull 1 additional part with MLEXS 093 F600607 to be used for structural test.	PH.	08.07.18.		 08.07.18	 08.07.18	

Part No: D3774-3 PAR #: N/A Fault Category: Thermoforming NCR: Yes No DQA: 11 Date: 08.08.21
D412-769-043/044 QA: N/C Closed: 12 Date: 08/09/26

NCR: <u>40588</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.07.18	04.	MLEXS 093 F600607 & 1 "Too hot" did not form.	<i>[Signature]</i>	Scrap & Replace. Qty M H105494	08.07.18 PH	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
08.07.23	06.	TRIMMED CENTER CUT OUT TOO HIGH. OPERATOR ERROR.	<i>[Signature]</i>	Qty 1 Scrap. No replace	08.07.23 PH.	<i>[Signature]</i>	<i>[Signature]</i>	<i>[Signature]</i>
08.08.12	08.	1 unit used for structural test	PH	Retain for R.E.D	08.08.12 PH.	<i>[Signature]</i>	PH	<i>[Signature]</i>
08.08.12	4	1 unit made with 093 not used for test.	ASIOH 03.06.12	Scrap 1 unit M H105494.	08.08.12 PH	<i>[Signature]</i>	01.08.12	<i>[Signature]</i>

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 12:31:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK (AFT FACING LH/RH)

Job Number: 40588

Part Number: D37743

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



DL 08.07.12

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/07/24 X

DL

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/07/24 X

PTO

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

UBA25

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

SB

08/08/15

(4)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



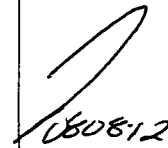
Comment: FINAL INSPECTION/W/O RELEASE

08/08/15

Job Completion



MF 08-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.08.12	7	DIMENSION 1.0 IS 0.6 0.6 (ZN C4-3) WIDTH OF CUTOUT IS 2.4 (ZN C7-3) AS TESTED ∴ ACCEPTABLE DEVIATION NON-STRUCTURAL	PH	08.08.12	4	PH 08.08.12 QSI 042	 080812

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	40598
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

15/ FOR TESTING
RETAIN FOR R AND D

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	AM
Free of visual flaws (bumps, cracks, voids, etc.)	AM

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.29.6	✓			
1.9"	+/- 0.100"	1.88	✓			
33.9"	+/- 0.100"	34	✓			
0.100"	MIN	.86		✓		
0.150"	MIN	.113		✓		
0.150"	MIN	.120		✓		
0.150"	MIN	.112		✓		
0.150"	MIN	.99		✓		
0.150"	MIN	.113		✓		
0.150"	MIN	.112		✓		
0.150"	MIN	.107		✓		

0.06

MIN

0.055

✓

Measured by: <u>AS</u>	Audited by: <u>[Signature]</u>	-Prototype Approval:
Date: <u>08/07/24</u>	Date: <u>08/14/25</u>	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD	WORK ORDER:	40588
Description: Seat Back (Aft Facing)	Part Number:	D37743
Inspection Dwg: D3774 Rev: A <i>B</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#2

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	<i>BR</i>
Free of visual flaws (bumps, cracks, voids, etc.)	<i>BR</i>

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. ___ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.27	✓			
1.9"	+/- 0.100"	1.93	✓			
33.9"	+/- 0.100"	34	✓			
<i>0.100"</i> <i>0.005</i>	MIN	101	✓			
<i>0.150"</i> <i>0.100</i>	MIN	136		✓		
<i>0.150"</i>	MIN	137		✓		
<i>0.150"</i>	MIN	121		✓		
<i>0.150"</i>	MIN	130		✓		
<i>0.150"</i>	MIN	119		✓		
<i>0.150"</i>	MIN	132		✓		
<i>0.150"</i> <i>0.100</i>	MIN	127		✓		

Measured by: <i>BR</i>
Date: <i>08/07/24</i>

Audited by: <i>A</i>
Date: <i>10/08/24</i>

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
		New Issue		

DART AEROSPACE LTD		WORK ORDER:	40588
Description: Seat Back (Aft Facing)		Part Number:	D37743
Inspection Dwg:	D3774	Rev:	A B
			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

5

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	BB
Free of visual flaws (bumps, cracks, voids, etc.)	BB

(Step 6) Trimming
FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. ____ and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100"	1.25	✓			
1.9"	+/- 0.100"	1.91	✓			
33.9"	+/- 0.100"	33.95	✓			
0.100" 0.085	MIN	.102	✓			
0.150" 0.100	MIN	.132		✓		
0.150"	MIN	.133		✓		
0.150"	MIN	.118		✓		
0.150"	MIN	.135		✓		
0.150"	MIN	.127		✓		
0.150" 0.100	MIN	.141		✓		

Measured by: BB	Audited by: [Signature]	Prototype Approval:
Date: 08/07/24	Date: 08-08-12	Date:

Rev	Date	Change	Revised by	Approved
		New Issue		



ATTN: CHANTAL

GE Polymershapes

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER : PO00004161

OUR SHIPPER NO: 078178

LINE ITEM # .1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 125 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25. 853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

JON CALDWELL
BRANCH MANAGER

Receiving Report

Date: 07/08/16

Batch No: 11105330

Supplier: GE Polymershapes

Dart P/O: 4161

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
 Waybill Attached: Yes ☒ No ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection On Hold N/A ☒
 Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

[Signature]

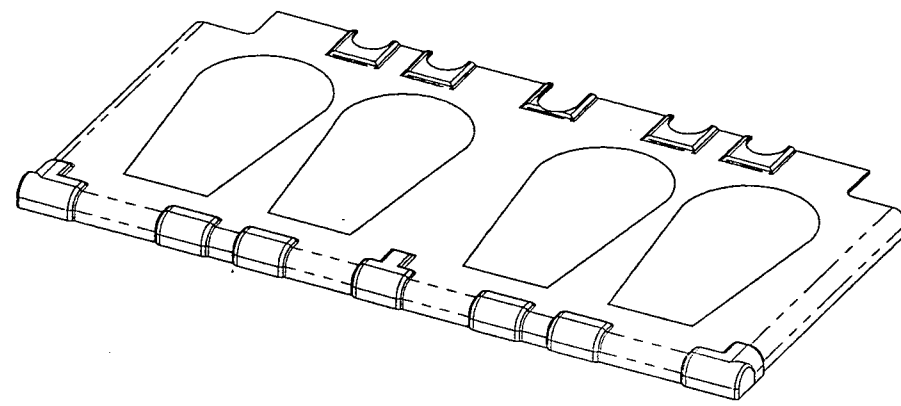
Production/Admin:

Date: 07/08/20
 Received/Costing: RIP 5411
 Initial: CS

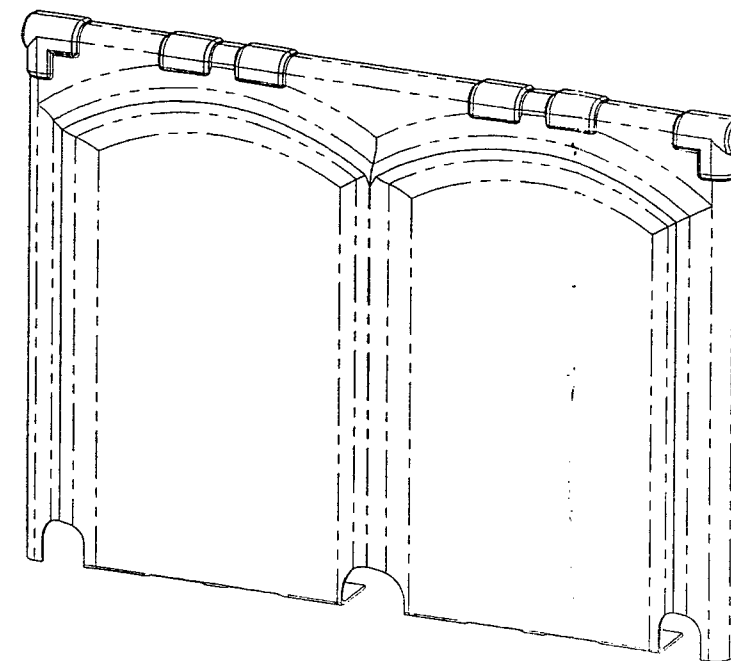
Location: _____

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

** PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION**
 THANK YOU
 EMAIL/FAX INFO _____



D3774-1 SEAT BOTTOM

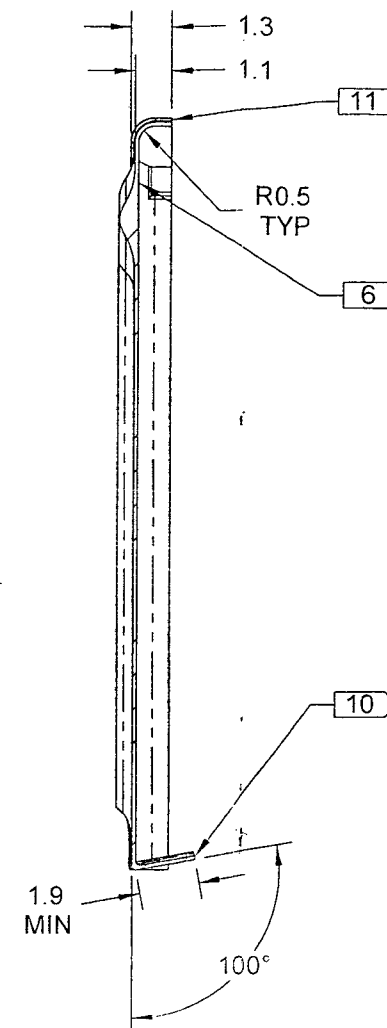
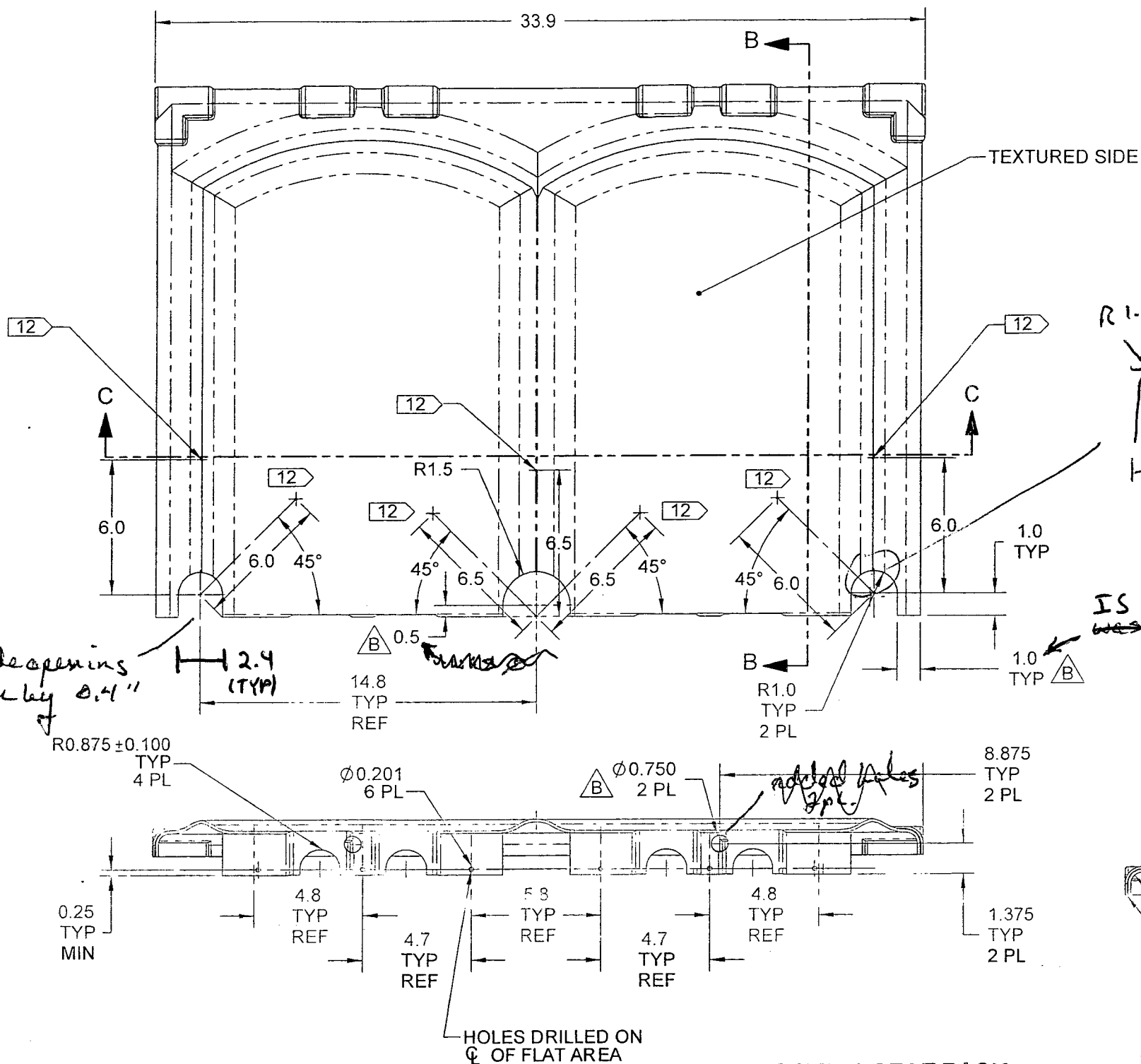


D3774-3 SEAT BACK

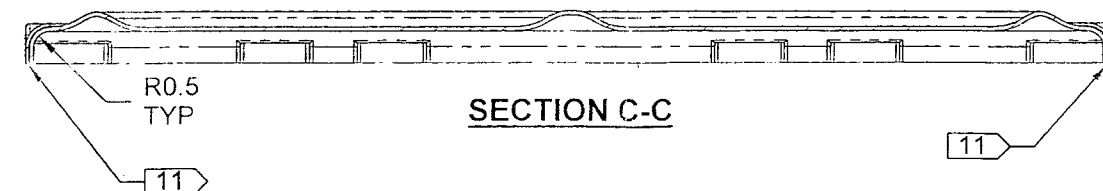
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40588

RELEASED
08-08-11/14

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.06.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40588

D3774-3 SEAT BACK

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
- 7) WEIGHT: 4.82 lbs
- 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
- 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
- 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
- 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
- 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED
08-08-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PG		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	